

Date: Tuesday, 1/3/2006 4:14:50 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET
Job Number	: 25347		
Estimate Number	: 10033		
P.O. Number	: N/A	Part Number	: D6101003
This Issue	: 1/3/2006 S.O. No. : N/A	Drawing Number	: D6101 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25346	Material	: N/A
Written By	: <u>SEE COMMENT ROW</u>	Due Date	: 4/15/2006 Qty: 100 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>		
Comment	: Est. A: 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 00000339 *AL 06/01/04*

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

*C 20/03/21**100*

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

*ml 06/04/07**100*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

*ml 06/04/07**100*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/04/10

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:14:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25347

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

[Signature] 06/04/10 (100)

Job Completion



6.06.04.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

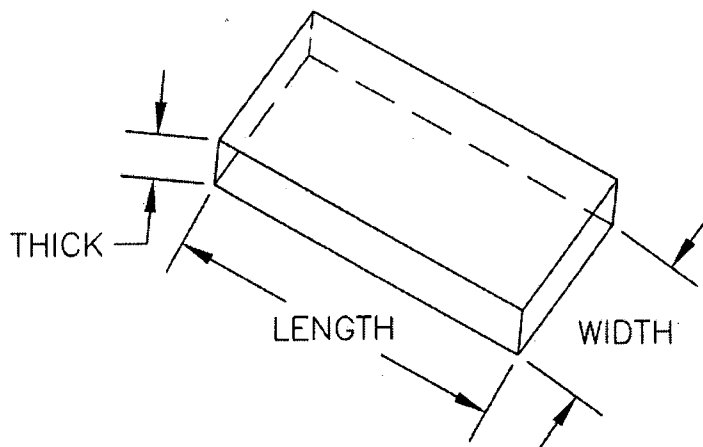
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED S	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23



SHOP COPY
RETURN TO
ENGINEERING
ROLLED COPY
INDEMENT

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO.		COMPTÉ-ACCT.	VEND. SLS	TERR.	EXPÉDIE PAR-SHIP VIA			
		PU 00000339		91037	200	40	CABANO (PRD)			
HETEUR-PURCHASING AGENT		TELEPHONE	H/C	TAXE	NO. COM ORD	REGION LIVRAISON-DEL ZONE		F.A.B.-F.O.B.	BILL	NO. FEVILLE/EMBALLAGE-B/L NUMBER
INDA LACELLE		613 632-3336	9	0	1	C/C		HAWKESBURY		A10647
RE A-SHIP TO:		VENDU A-SOLD TO:				INFORMATION CREDIT-CREDIT INFORMATION			ROUTE	
		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7				REC SEE FRANCE STATUS			01-NL-03/05 30-NL-03/10 31-NL-03/25	
INSTRUCTIONS/LIVRAISON-DELIVERY		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)				INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)				
INQ-L26184										

SCRIPTION - ITEM 1		QTE/UNITE COM.-ORDERED		PCES/COM.ORD.	POIDS COM.-WT. ORDERED	
2.0000 PLATE 7075-17351 ALUM 6.25" X 7.875"		100 PCS		PCS	995	
BLACK W/RED STRIPE		BALLOTS-BUNDLES		PCES/PD EXP. SHP.	POIDS EXP.-WT. SHIPPED	
1		100		995		
CERTIFICATE OF CONFORMANCE		INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY
A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc.		TOL: +.030" / -.000" THICKNESS TOL: +.030" / -.000" GRAIN TO RUN ALONG 7.875" PRIOR DIST/ORD: 01 584374		353730 AS		
WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.		INSTRUCTIONS (CONT'D.)		INSTRUCTIONS (CONT'D.)		ENT-WH
		100 X 6.25" X 7.875"				

SCRIPTION - ITEM 2		QTE/UNITE COM.-ORDERED		PCES/COM.ORD.	POIDS COM.-WT. ORDERED	
TERMS AND CONDITIONS OF SALE		BALLOTS-BUNDLES		PCES/PD EXP. SHP.	POIDS EXP.-WT. SHIPPED	
SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE						
INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY		
1 SKID						
INSTRUCTIONS (CONT'D.)		INSTRUCTIONS (CONT'D.)		INSTRUCTIONS (CONT'D.)		ENT-WH

SCRIPTION - ITEM 3		QTE/UNITE COM.-ORDERED		PCES/COM.ORD.	POIDS COM.-WT. ORDERED	
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.		BALLOTS-BUNDLES		PCES/PD EXP. SHP.	POIDS EXP.-WT. SHIPPED	
INSTRUCTIONS		COULÉE INFO-HEAT INFO		QTE-QTY		
INSTRUCTIONS (CONT'D.)		INSTRUCTIONS (CONT'D.)		INSTRUCTIONS (CONT'D.)		ENT-WH

NOM (LETRE MOULEE)-NAME (PRINT ONLY)		DATE RECU-DATE RECEIVED	
RECU PAR-RECEIVED BY			

FEVILLE D'EMBALLAGE PACKING SLIP

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
SOLD TO: AM CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
 4061386

CUSTOMER PO NUMBER: 01-81949		WORK PACKAGE:		CUSTOMER PART NUMBER: 8857		SHIP RUN/LOAD ID: 100608/12		GOVT CONTRACT NUMBER: A97075-60	
KAISER ORDER NO: 1032379	LINE ITEM: 1	SHIP DATE: 2-MAR-2006		ALLOY: 7075		CLAD: BARE		TEMPER: T7351	
WEIGHT SHIPPED: 5758 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 207823		GAUGE: 2.0000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevF
 ASTM B 209/Rev04
 BSS 7055/RevA
 EAC MS1011/RevA
 MMS 159/RevN

AMS-QQ-A-250/12
 ASTM B 594/Rev02
 CSTI 006/RevB
 GSS16100/RevG
 PS 21211/RevJ

AMS-STD-2154
 BAC 5439/RevH
 DPS 4.713/RevN/AmdAF
 MIL-STD-2154

Test Code: 4297

Test Results

Lot: 353730A5 Cast 878

Drop 03

Ingot 4

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.1 : 73.6 (504 : 507)	62.4 : 62.8 (430 : 433)	11.9 : 11.9

Conductivity %IACS :	41.7 Min	41.8 Max
(MS/M) :	24.2 Min	24.2 Max

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.19	1.44	0.01	2.45	0.19	5.73	0.02	0.01	0.00	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
 DATE REC'D 3.6.06 IAC 6857
 APPROVED BY: *[Signature]*

**KAISER
ALUMINUM****CERTIFIED TEST REPORT**

Serial Number

4061386

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR